

Work Order ID 140268 -1

140268

To ship Jan 7 & 11th

December 18, 2015 2:52:16 PM

Page 1

Item ID: D412-775-013 *SPLIT* Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Protective Trim
 Start Date: 12/18/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/15/2016 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: *SEA* Date: 20151218 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9503	A
IIN D412-775	Rev A

100 Document Control 0.00
 100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D412-775-013 CHG003

105 Pick Kit 0.00
 105
 Packaging Memo 0.00
 Packaging

SMS 6/11/14

5

DEC 21 2015

DAS
26
9-89

Work Order ID 140268

December 18, 2015 2:52:16 PM

140268

Page 2

Item ID: D412-775-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Protective Trim
 Start Date: 12/18/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/15/2016 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-775-013 Location: FG028								
130		0.00							
130	QC21- Final Inspection - Work Order Release								
QC	Memo	0.01							
Quality Control									

SMB
16/1/15

SMB
16/1/15

2x sold
3x fg 028

MCS JAN 05 2016

MCS JAN 05 2016

Picklist Print

December 18, 2015 2:52:22 PM

Page 1

Work Order ID: 140268

140268

Parent Item: D412-775-013

D412-775-013

Parent Item Name: Step Protective Trim

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-10 new issue DD verified by:ec
kit DD 10.02.18 Verified By:EC
IPP Rev:B add pick

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3608-1		Manufactured	No			110	Each	5.0000	1				
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D3608-1

Lower Doubler

SMB SX

Location

Loc Qty

Loc Code

ST505

5

130504

5

D3608-3		Manufactured	No			110	Each	6.0000	1	6			
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D3608-3

Upper Doubler

SMB SX

Location

Loc Qty

Loc Code

ST505

6

130503

6

DEC 21 2015

54
20151218 150268

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0

REF. TCCA STC SH08-53
REF. FAA STC SR02692NY
REF. EASA STC EASA.IM.R.S.01529

It has come to Dart's attention that due to variances in airframe, the D3608-1/-3 Lower/Upper Doublers of the D412-775-013 Step Protective Trim Kit at CHG 001 may not always fit as intended. To ensure proper fit, Dart has made changes to both D3608-1/-3 Doublers at CHG 002 and later. The manuals listed above are amended as follows:

IS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

WAS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

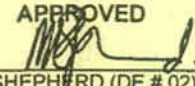
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

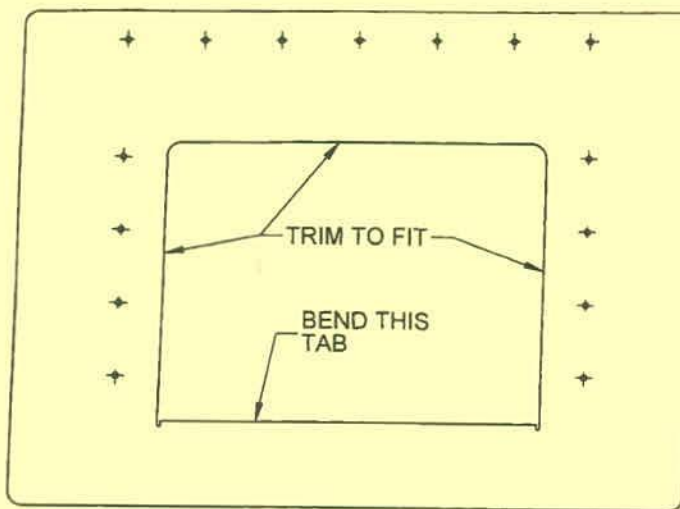
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

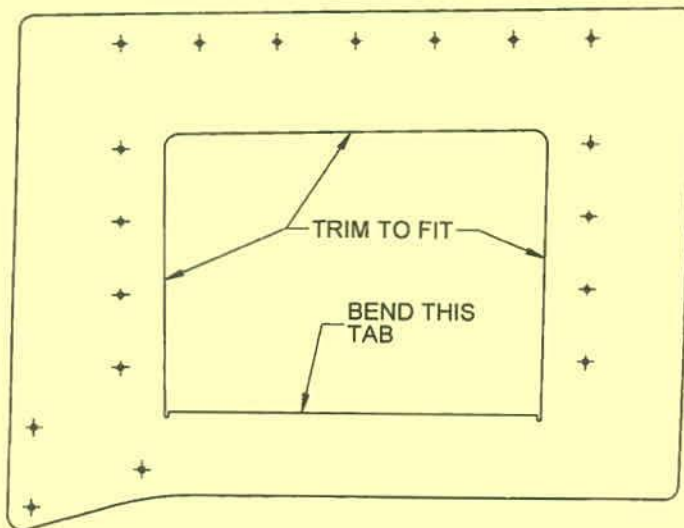
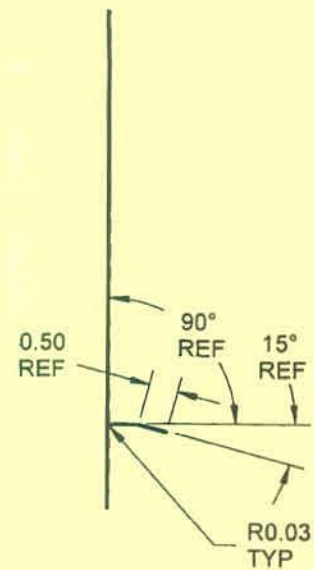
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

A	NEW ISSUE	MB	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP PROTECTIVE TRIM CHG NTS	
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D3608-3 BENT UPPER DOUBLER



D3608-1 BENT LOWER DOUBLER

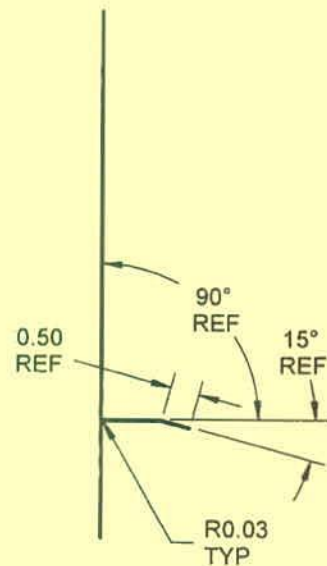


FIGURE 1: TRIMMING/BENDING OF D3608-1/-3 DOUBLERS
(PARTS SHOWN PRIOR TO TRANSFER DRILLING)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
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DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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53.7 WEIGHT AND BALANCE

INSTALLATION	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-775-011 Door Sill Protective Trim Kit	1.20 lb 0.54 kg	0 in 0 m	0 in lb 0 m kg	45.5 in 1.16 m	54.3 in lb 0.63 m kg
D412-775-013 Step Protective Trim Kit	1.25 lb 0.57 kg	+44.8 in +1.14 m	+56.0 in lb +0.65 m kg	69.0 in 1.75 m	86.25 in lb 1.00 m kg
D412-775-015 Fuel Panel Protective Trim Kit	1.39 lb 0.63 kg	+41.5 in +1.05 m	+57.7 in lb +0.66 m kg	172 in 4.37 m	239.1 in lb 2.75 m kg

53.8 PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-775-011	DOOR SILL PROTECTIVE TRIM KIT
	X		D412-775-013	STEP PROTECTIVE TRIM KIT
		X	D412-775-015	FUEL PANEL PROTECTIVE TRIM KIT
2			D3602-1	ANGLE
	1		D3608-1	LOWER DOUBLER
	1		D3608-3	UPPER DOUBLER
		1	D3609-1	DOUBLER

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